

IN THE CLAIMS

1. (Currently Amended) A method of manufacturing a rigid foam comprising:

incorporating nano-particles into a polymer melt, said nano-particles being selected from the group consisting of nano-clays, calcium carbonate, intercalated graphites and expanded graphites;

incorporating a blowing agent into the polymer melt under a first pressure and at a first temperature;

extruding the polymer melt under a second pressure and at a second temperature, the second pressure and second temperature being sufficient to allow the polymer melt to expand and form a foam; and

cooling the foam to form a foam product having an average cell size, ~~a cell size distribution, an average cell wall thickness, an average cell strut diameter, a cell orientation, a thermal conductivity, a foam density and a foam strength,~~ said average cell size being greater than approximately 60 μm and having a monomodal cell size distribution.
2. (Original) A method of manufacturing a rigid foam according to claim 1, wherein:

the polymer includes a major portion of at least one alkenyl aromatic polymer selected from a group consisting of alkenyl aromatic homopolymers, copolymers of alkenyl aromatic compounds and copolymerizable ethylenically unsaturated comonomers.

3. (Previously presented) A method of manufacturing a rigid foam according to claim

2, wherein:

the polymer includes a major portion of at least one alkenyl aromatic polymer selected from the group consisting of the polymerization products of styrene, α -methylstyrene, chlorostyrene, bromostyrene, ethylstyrene, vinyl benzene and vinyl toluene; and

a minor portion of a non-alkenyl aromatic polymer.

4. (Original) A method of manufacturing a rigid foam according to claim 3, wherein:

the polymer includes at least 80 wt% polystyrene.

5. (Original) A method of manufacturing a rigid foam according to claim 2, wherein:

the blowing agent includes at least one composition selected from a group consisting of aliphatic hydrocarbons having 1-9 carbon atoms, halogenated aliphatic hydrocarbons having 1-4 carbon atoms, carbon dioxide, nitrogen, water, azodicarbonamide and p-toluenesulfonyl.

6. (Previously Presented) A method of manufacturing a rigid foam according to claim

5, wherein:

the blowing agent includes at least one composition selected from a group consisting of methane, methanol, ethane, ethanol, propane, propanol, n-butane, isopentane, carbon dioxide, nitrogen, water, azodicarbonamide, p-toluenesulfonyl, HCFC-142b and HCFC-134a.

7. (Original) A method of manufacturing a rigid foam according to claim 2, further comprising:
incorporating an additive into the polymer melt before forming the foam.
8. (Original) A method of manufacturing a rigid foam according to claim 7, wherein:
the additive includes at least one composition selected from a group consisting of flame retardants, mold release agents, pigments and fillers.
9. (Currently Amended) A method of manufacturing a rigid foam according to claim 2, wherein:
the nano-particles have a minimum dimension of less than about 100 nm and said nano-clays are further selected from the group consisting of intercalated clays and exfoliated clays.
10. (Original) A method of manufacturing a rigid foam according to claim 9, wherein:
the nano-particles are incorporated into the polymer melt at a rate of between 0.01 and 10 weight percent, based on polymer weight.
11. (Original) A method of manufacturing a rigid foam according to claim 9, wherein:
the nano-particles are incorporated into the polymer melt at a rate of between 0.5 and 5 weight percent, based on polymer weight.

12. (Original) A method of manufacturing a rigid foam according to claim 11, wherein:
the nano-particles include a major portion of nano-Montmorillonite (MMT); and
the polymer includes a major portion of polystyrene (PS), polyethylene (PE) or
polymethyl methacrylate (PMMA).
13. (Original) A method of manufacturing a rigid foam according to claim 10, wherein:
the nano-particles are formed by a technique selected from a group consisting of
intercalation with polystyrene, in-situ polymerization of polystyrene (PS) or polymethyl
methacrylate (PMMA) with a surface modified nano-Montmorillonite (MMT), and
exfoliation of expandable graphite particles in a polystyrene or polymethyl methacrylate
matrix.
14. (Currently Amended) A method of manufacturing a rigid foam according to claim 2,
wherein:
~~the average cell size is less than about 500 μm ;~~
the average cell wall thickness is less than about 10 μm ;
the average strut diameter is less than about 20 μm ;
the cell orientation is between about 0.5 and 2.0; and
the foam density is less than about 100 kg/m^3 .

15. (Original) A method of manufacturing a rigid foam according to claim 14, wherein:

- the average cell size is between about 60 and about 120 μm ;
- the average cell wall thickness is between about 0.2 and about 1.0 μm ;
- the average strut diameter is between about 4 and about 8 μm ;
- the cell orientation is between about 1.0 and about 1.5; and
- the foam density is between about 20 and about 50 kg/m^3 .

16. (Original) A method of manufacturing a rigid foam according to claim 2, further comprising:

- incorporating a conventional nucleation agent into the polymer melt at a rate of less than about 2 weight percent based on polymer weight.

17. – 20. Canceled

21. (Currently Amended) A method of manufacturing a monomodal rigid foam comprising:

- incorporating acicular nano-particles into a polymer melt;
- adding a blowing agent to said polymer melt under a first pressure and at a first temperature;
- extruding said polymer melt under a second pressure and at a second temperature, said second pressure and said second temperature being sufficient to allow said polymer melt to expand and form a foam; and
- cooling said foam to form a foam product having a monomodal cell size distribution.

22. (Previously Presented) The method of claim 21, further comprising the step of:

incorporating a nucleating agent into said polymer melt.
23. (Previously Presented) The method of claim 21, wherein said foam has a cell orientation of at least about 1.2.
24. (Currently Amended) A method of manufacturing a rigid foam comprising:

incorporating nano-particles into a polymer melt, said nano-particles being selected from at least one nano-particle selected from calcium carbonate, intercalated graphites, and expanded graphites;

adding a blowing agent to said polymer melt under a first pressure and at a first temperature;

extruding said polymer melt under a second pressure and at a second temperature, said second pressure and said second temperature being sufficient to allow said polymer melt to expand and form a foam; and

cooling said foam to form a foam product having an average cell size between greater than about 60 and about 120 μm .